



DESIGN DS	DRAWN BY DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DEO 9109	REV. A SHEET 1 OF 1
DATE 98.08.24		TITLE ALUMINUM WELDING COUPON TESTING	SCALE NTS
A 98.08.24		NEW ISSUE	

DART ENGINEERING ORDER

TO AMEND QSI 004 ISSUE 2

THE FOLLOWING PROCEDURE SHOULD BE PERFORMED ON A WEEKLY BASIS OR WHENEVER THE TYPE OF SKIDTUBE IN PRODUCTION CHANGES:

1. WELD (2) CROSSBOLT SPACERS INTO A SAMPLE PIECE OF SKIDTUBE EXTRUSION ($\approx 6"$ LONG) PER THE APPLICABLE DWG (SEE SKETCH BELOW)
2. GRIND DOWN BOTH ENDS OF ONE CROSS BOLT SPACER UNTIL THE END OF THE SPACER IS VISIBLE OR A VOID IS OBSERVED. MEASURE ACROSS THE CROSSBOLT SPACER TO CHECK FOR PENETRATION TO THE BOTTOM OF CHAMFER IN THE SKIDTUBE.
3. CUT LONGITUDINALLY THROUGH THE OTHER CROSSBOLT SPACER. CHECK FOR VOIDS OR PENETRATION TO THE BOTTOM OF THE CHAMFER IN THE SKIDTUBE EXTRUSION.
4. IDENTIFY THE TEST COUPON WITH THE WELDER'S NAME AND DATE THAT THE TEST WAS PERFORMED. FILL IN THE MIL-STD-1595A QUALIFICATION TEST RECORD. RETAIN COUPON.
5. IF THE TEST IS UNSUCCESSFUL, REPORT IT TO THE MANUFACTURING MANAGER IMMEDIATELY FOR DISPOSITION. IF THE TEST IS SUCCESSFUL, CONTINUE WITH PRODUCTION.

